

Work Order ID 92648

92648

Page 1

November-06-12 12:28:58 PM

Item ID: D4034-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Upper Rib Assembly

Start Date: 11/14/12 Start Qty: 1.00

1 (3x)
1

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 1.00

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: MLS

Date: 12-11-07 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4034	B
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100 Weld per dwg A/R S.S. rod Batch: 1122130 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

CC 12-11-20

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

(3) 12-11-21

DAS
09
8-88

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

(3) 12-11-21

DAS
09
8-88

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Setup Start *NS1*

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Required Date: 11/23/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>WIA</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(3x) CC 12-11-21

12/11/22 *[Signature]*
ME
12-11-21

Picklist Print

November-06-12 12:28:58 PM

Page 1

Work Order ID: 92648
Parent Item: D4034-041
Parent Item Name: Aft Upper Rib Assembly

Start Date: 11/14/12 Required Date: 11/23/12
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15
verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4034-1 Rib		Manufactured	No			100	Each	11.0000	1	1		CC 17-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		11		B 89319			(3x)		
				83755		1							
				86176		10							
D4034-3 Rib		Manufactured	No			100	Each	10.0000	1	1		CC 17-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10		B 89359			(3x)		
				58408		0							
				84590		1							
				89319		9							
✓ D4021-7 Hoop		Manufactured	No			100	Each	41.0000	1	1		CC 17-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		41							
				56996		0							
				87487		1							
				88428		27					(3x)		
				89265		13							

Picklist Print

November-06-12 12:28:58 PM

Work Order ID: 92648

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 11/14/12

Required Date: 11/23/12

Start Qty: 1.00

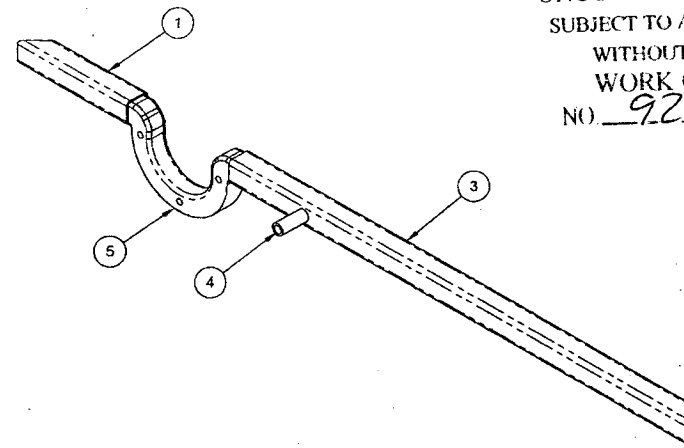
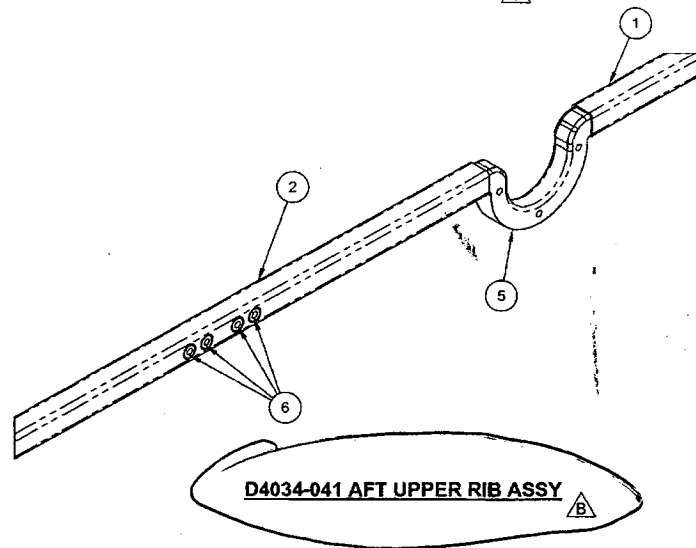
Required Qty: 1.00

✓ D4021-9 Manufactured No
Bushing

100 Each 130.0000 4 4 CC 12-11-20

Location	Loc Qty	Loc Code
WA	120	
66437	0	
72482	0	
82977	1	
84717	3	
88077	23	
88377	7	
92020	86	12x
WA005	10	
66437	2	
70333	4	
72482	4	

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



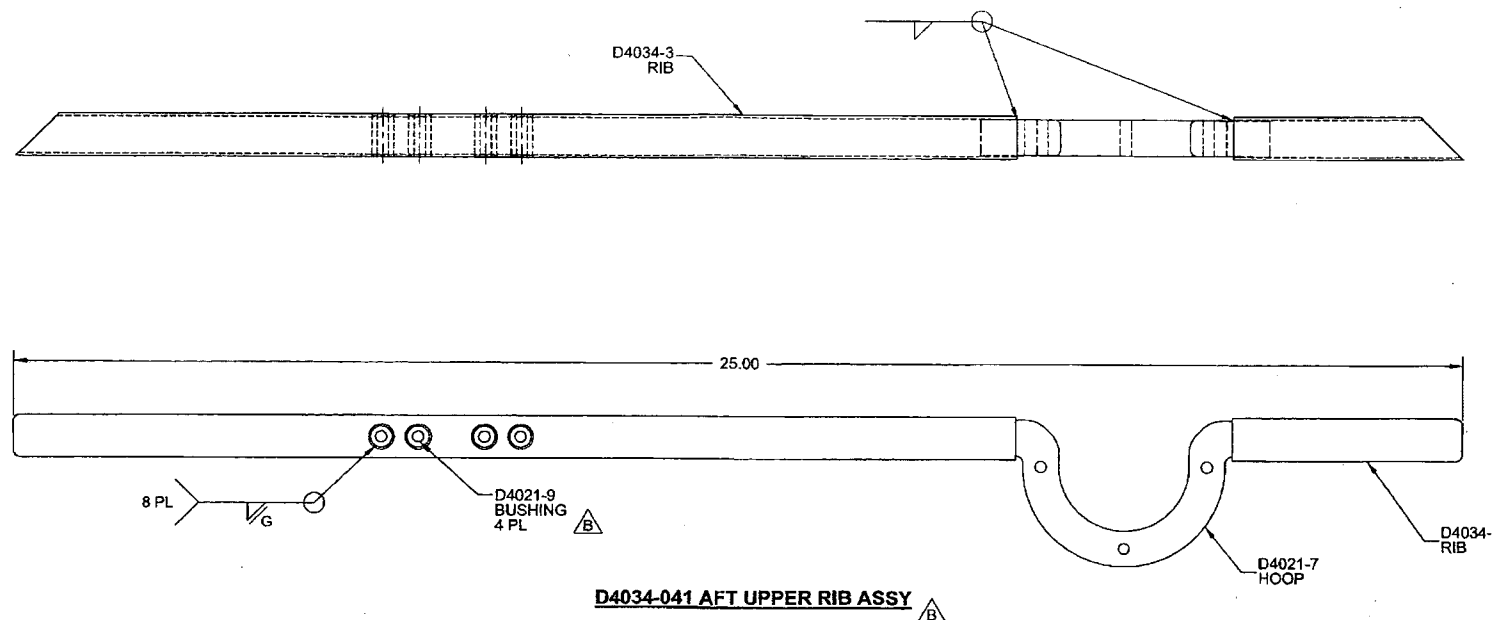
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 92648 MLJ
12-11-07

D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18
JM

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	R	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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92648



D4034-041 AFT UPPER RIB ASSY

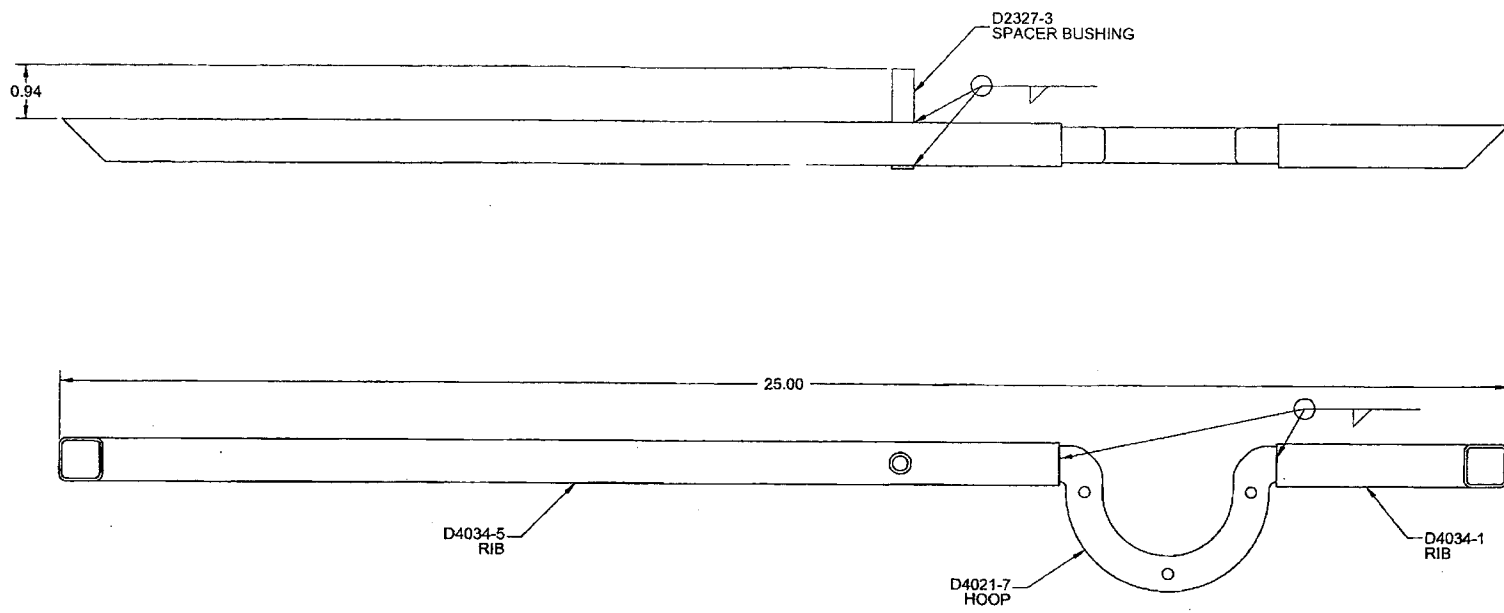
RELEASED
2011-01-30

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 2 OF 4
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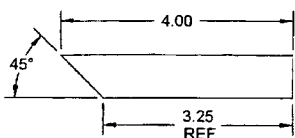


D4034-043 FWD UPPER RIB ASSY

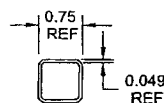
RELEASED
R 2011-01-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

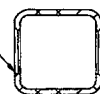
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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D4034	SHEET 3 OF 4
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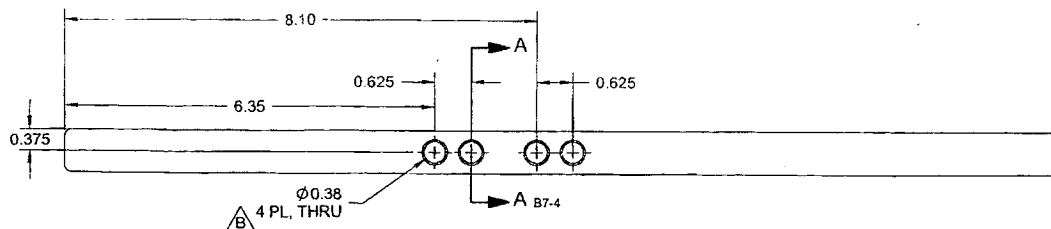
D4034-1 RIB



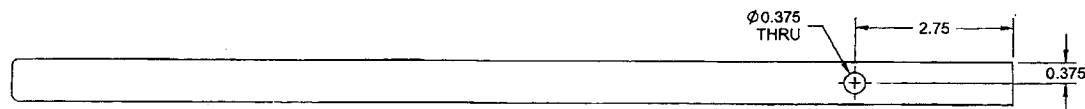
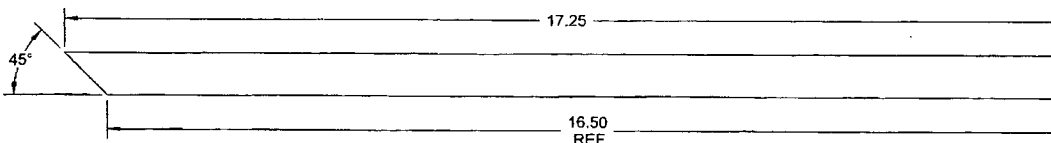
BREAK EDGE
0.030 X 45°
TYP



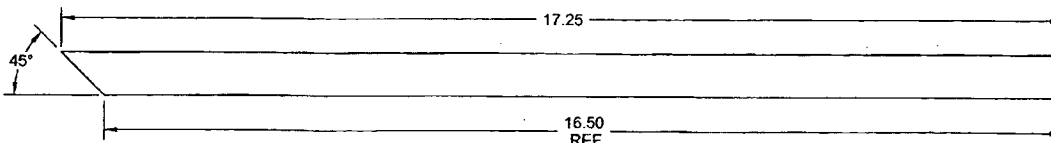
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	SC	DRAWING NO. D4034	REV. B
MFG. APPR.		SHEET 4 OF 4	
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2011-01-10
NR

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